

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006499**Date Inspected:** 01-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG				

**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Erik Prue was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA Inspector observed and/or found the following:

Segment 5BW: QA Inspector received notification that segment 5BW interior top has been blast cleaned and the welds and base material have been visually inspected by ABF and ZPMC QC personnel and is ready for QA visual inspection verification. QA Inspector performed visual verification on QC inspectors accepted welds and base material on the interior top of the segment. QA Inspector marked Thirty Four (34) indications (arc strikes, unacceptable weld profile, base material mishandling, rollover, and weld spatter) that are unacceptable to AWS D1. 5 (02) section 6.26. QA Inspector informed ABF QC and ZPMC QC personnel of the indications marked. ABF QC and ZPMC QC concurred with QA Inspectors findings and marked indication areas for repair. ZPMC QC directed workers to repair the marked indications by grinding. QA Inspector marked Seven (7) indications for weld repair. Indications are lack of fusion located at welds on deck plate diaphragm plates to deck plate and closed u-ribs at panel point 34 looking towards panel point 35. The areas marked for weld repair are taped and will be corrected after painting when segment is moved to segment splicing area. Specific locations of areas requiring weld repair are tracked on segment tracking spread sheet. ABF QC and ZPMC QC will reinspect the areas repaired by grinding then inform QA Inspector when inspection is complete. Representative pictures of indications shown below.

QA Inspector continued OBG Segment tracking documentation control for sub assembly green tagging, segment weld repairs after blast cleaning, and segment splicing fit up dimensions taken.

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## WELDING INSPECTION REPORT

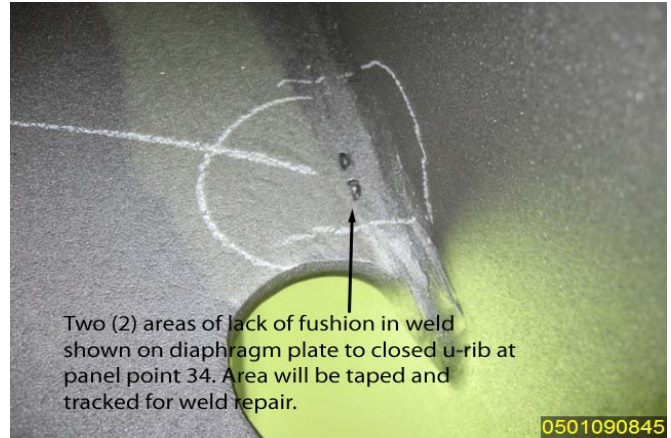
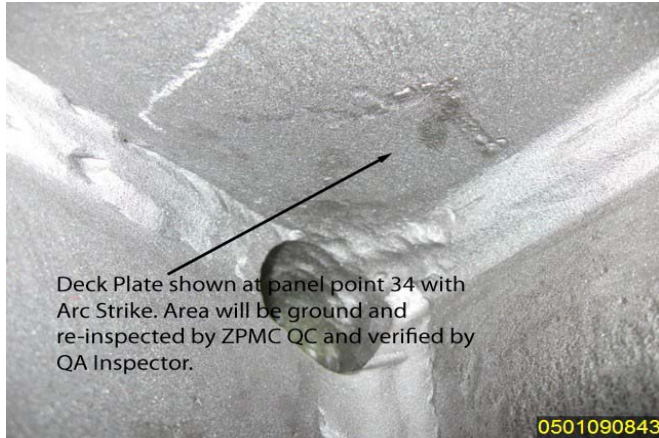
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Unless otherwise noted, all work observed on this date appears to be in general compliance with the applicable contract documents.

### Summary of Conversations:

No significant conversations this day.



### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prue,Erik	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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